

Work Order ID 57751

April 14, 2010 11:38:03 AM



Page 1

Item ID: D2360

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Tie Down Assembly

Start Date: 4/14/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/22/10 Req'd Qty: 6.00



Customer:

Reference:

Handwritten signature and date: 10.04.15

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2360

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.65" Long

Handwritten: H.A 10/04/15

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2341 and Dwg D2341
2-Debur

Handwritten: H.A 10/04/15

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*Handwritten: H.A 10/04/15
10.4.17*

Handwritten signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57751

April 14, 2010 11:38:03 AM



Page 2

Item ID: D2360	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Litter Tie Down Assembly				
Start Date: 4/14/10	Start Qty: 6.00		Cust Item ID:	
Required Date: 4/22/10	Req'd Qty: 6.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00	SP 10/24/18			6	0		
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00	JL 10/04/19			X6	0		
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo START TIME: 10:15AM OVEN TEMPERATURE: 320°F FINISH TIME: 10:45AM	0.00	JL 10/04/19			X6	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57751

April 14, 2010 11:38:04 AM

Page 3

Item ID: D2360

Accept

Setup Start

Revision ID:

Stop

Item Name: Litter Tie Down Assembly

Start Date: 4/14/10

Start Qty: 6.00

Cust Item ID:

Required Date: 4/22/10

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(6)

10-4-19

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D2360

10/05/17 (6)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/05/18

(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57751

April 14, 2010 11:38:10 AM



Page 4

Item ID: D2360

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Tie Down Assembly

Start Date: 4/14/10

Start Qty: 6.00



Cust Item ID:

Required Date: 4/22/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 224

0.00



Packaging

Memo

0.00

Packaging

10-5-18

605

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/19
MF
10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:37:58 AM

Page 1

Work Order ID: 57751

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly


Comments: IPP rev H 07.06.12 ecn 825 EC

Start Date: 4/14/10

Required Date: 4/22/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R18  Screw		Purchased	No			170	Each	595.0000	6.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST328

595

101458

71

108079

419

1523

105

* AN960JD10 *QSI 017 NAS 1149 D03633*

Purchased

No

170

Each

0.0000

12.0000

Washer

AN960JD10L

Purchased

No

170

Each

4,593.000

48.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

4593

110985

4593

D2002-015

Manufactured

No

170

Each

59.0000

12.0000

Knob

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST003

59

16177

59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:37:59 AM

Page 2

Work Order ID: 57751

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly



Comments: IPP rev H 07.06.12 ecn 825 EC

Start Date: 4/14/10

Required Date: 4/22/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2345  Lock Channel	✓	Manufactured	No			170	Each	0.0000	6.0000			
D2366  Lock Handle	✓	Manufactured	No			170	Each	1.0000	12.0000			

B57762 (10)

4/10/05/17

4/10/05/17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST012

1

42919

1

D2367



Handle Knob

Manufactured

No

170

Each

3.0000

6.0000



4/10/05/17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST012

3

42975

3

D2372



Quick Release

Manufactured

No

170

Each

9.0000

12.0000



4/10/05/17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST012

9

56453

9

B57765 (3x)

9

April 14, 2010 11:37:59 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 57751

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Comments: IPP rev H 07.06.12 ecn 825 EC

Start Date: 4/14/10

Required Date: 4/22/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2373		Manufactured	No			170	Each	13.0000	6.0000			
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Spring

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST012

13

42920

13

D2444

Manufactured No

170

Each

1.0000

6.0000



Pip Pin Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST014

1

54801

1

D6201

Manufactured No

100

f

13.0000

6.6568



"T" Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT05

13

56424

13

4/10/05/17

6
4/10/05/17

B57766 (5x)

1

6.3900 +1 N.A 10/04/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 57751

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Comments: IPP rev H 07.06.12 ecn 825 EC

Start Date: 4/14/10

Required Date: 4/22/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD3-4		Purchased	No			170	Each	11,447.00	6.0000			
--------------	--	-----------	----	--	--	-----	------	-----------	--------	--	--	--



Rivet, Universal Head

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST319

11447

111477

8332

15541

3115

MS21042L3		Purchased	No			170	Each	1,201.000	18.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Nut

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST300

1201

113537

217

113644

984

MS27039-1-13		Purchased	No			170	Each	70.0000	6.0000			
--------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



Screw

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST292

70

110844

70

April 14, 2010 11:38:00 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:38:00 AM

Page 5

Work Order ID: 57751



Parent Item: D2360



Parent Item Name: Litter Tie Down Assembly

Start Date: 4/14/10

Required Date: 4/22/10

Comments: IPP rev H 07.06.12 ecn 825 EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15 Screw		Purchased	No			170	Each	137.0000	12.0000			

EP 10/05/17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST292

137

112794

37

114056

100

12

NAS679A3W

Purchased

No

170

Each

231.0000

6.0000

Nut



EP 10/05/17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST280

231

1463

38

2409

193

6

April 14, 2010 11:38:00 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 57751
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

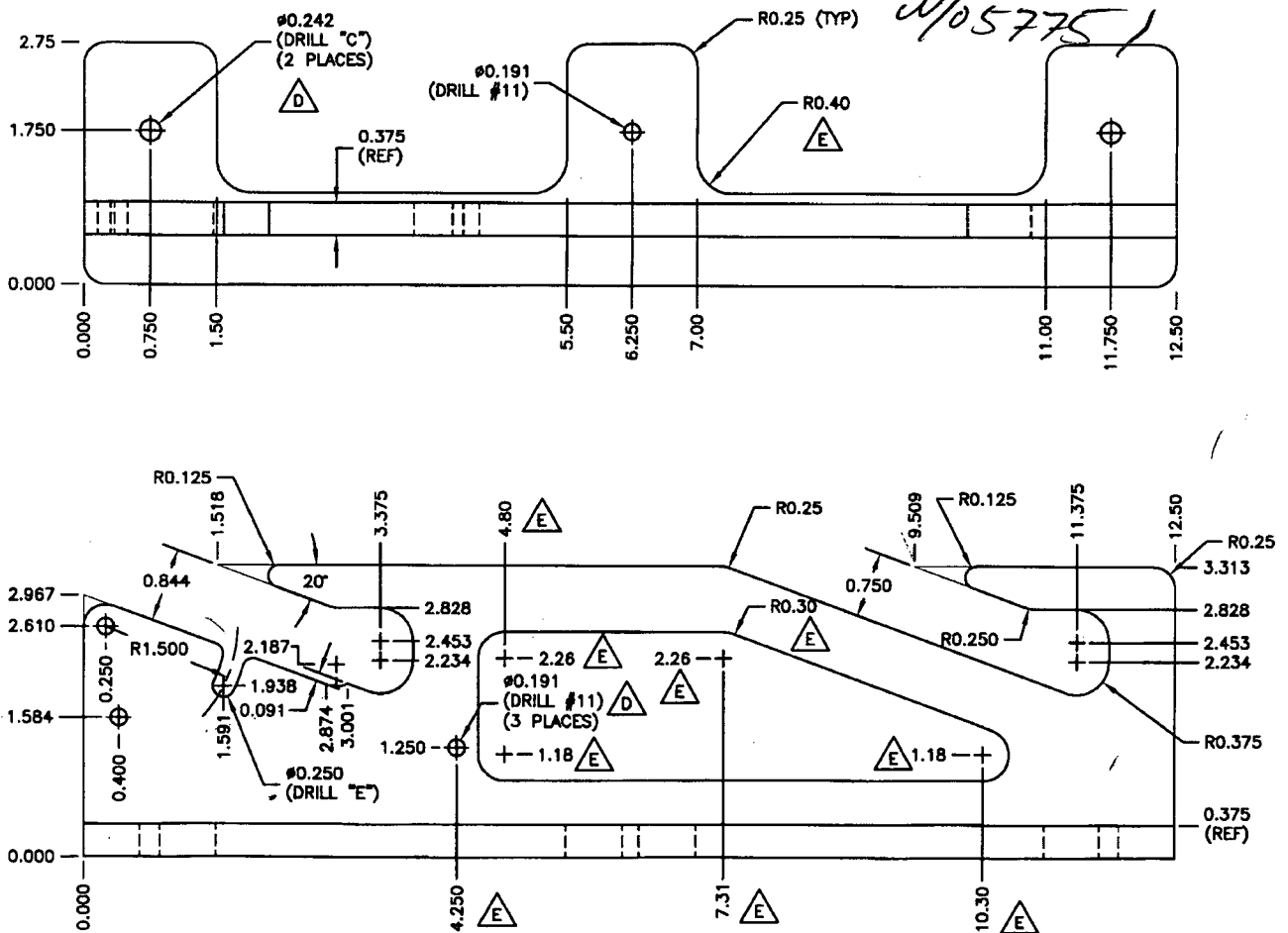
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2.75	+/-0.030	2.755	✓			
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Ø0.191	+0.005/-0.001	Ø0.195	✓			
R0.25	+/-0.030	R0.250	✓			
R0.40	+/-0.030	R0.400	✓			
12.50	+/-0.030	12.50	✓			
11.750	+/-0.010	11.750	✓			
11.00	+/-0.030	11.000	✓			
7.00	+/-0.030	7.000	✓			
6.250	+/-0.010	6.251	✓			
5.50	+/-0.030	5.50	✓			
1.50	+/-0.030	1.505	✓			
0.750	+/-0.010	0.756	✓			
0.400	+/-0.010	0.401	✓			
1.584	+/-0.010	1.578	✓			
2.610	+/-0.010	2.604	✓			
0.250	+/-0.010	0.253	✓			
0.844	+/-0.010	0.844	✓			
Ø0.250	+/-0.010	Ø0.253	✓			
0.750	+/-0.010	0.752	✓			
3.313	+/-0.010	3.313	✓			
4.250	+/-0.010	4.250	✓			
1.250	+/-0.010	1.246	✓			

Measured by: L.A	Audited by: SP	Prototype Approval:	N/A
Date: 10/04/15	Date: 10/04/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	

DART

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
(6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
PERMANENT INK MARKER

RELEASED

07-06-22

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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

97.06.07

w/o 5775/

PARTS LIST:

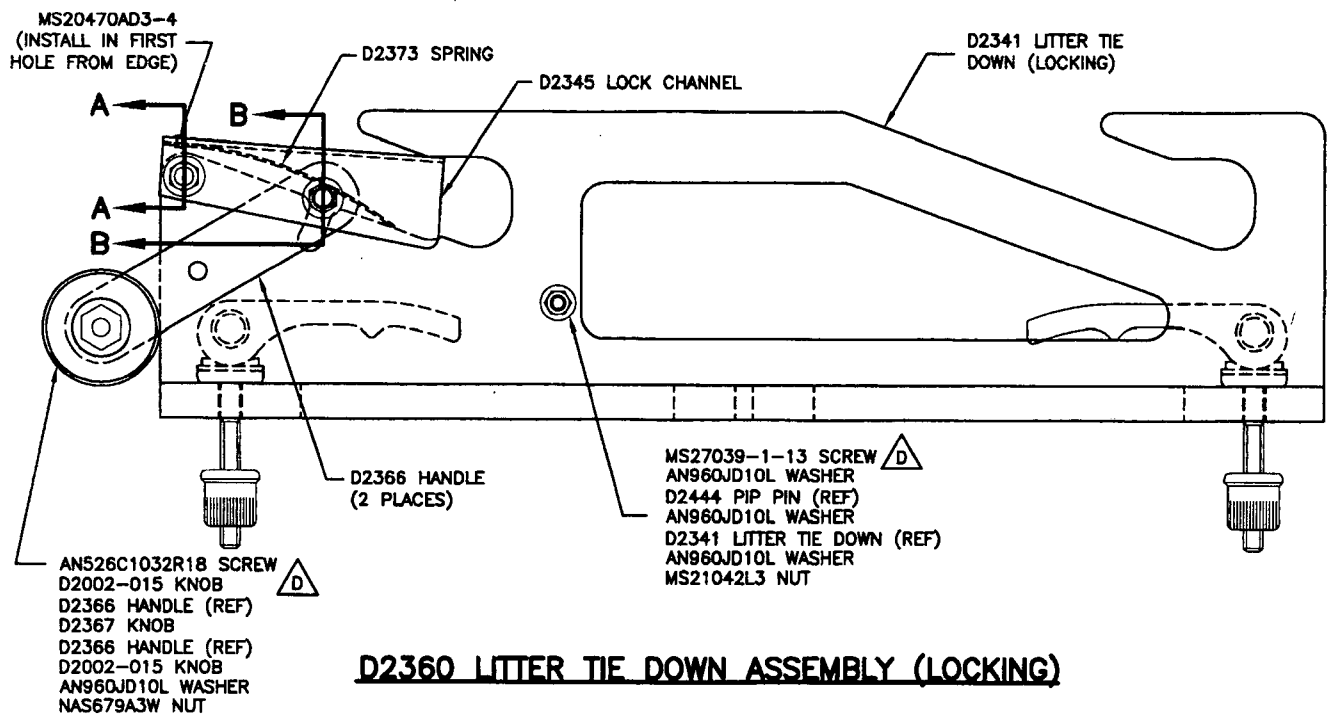
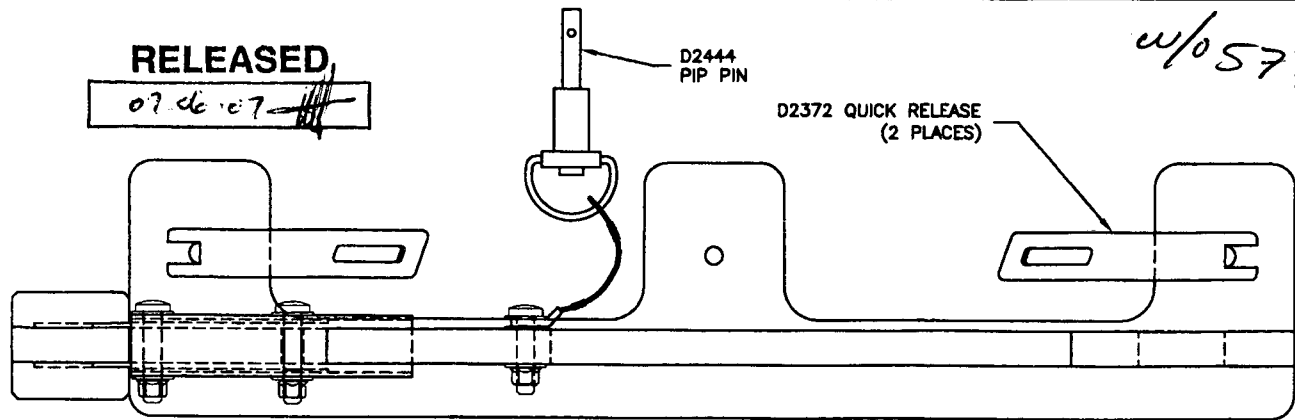
QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

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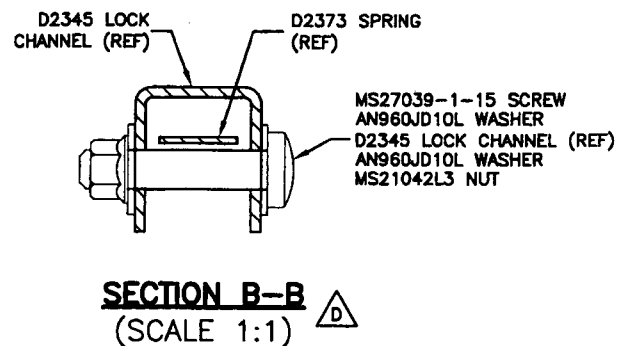
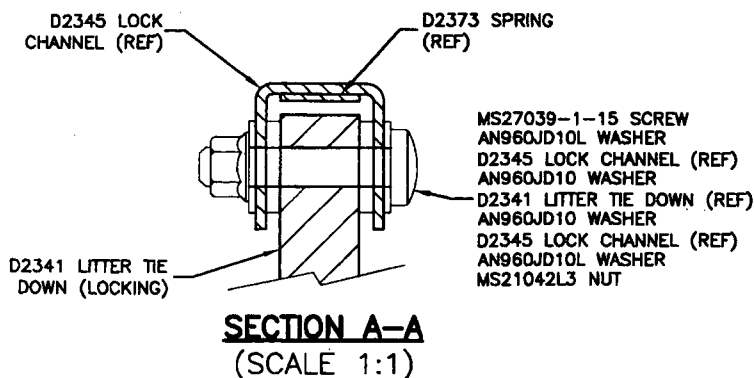
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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE



D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



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